



Dart Aerospace Ltd.
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D3200-1

Job Sheet 182257



Part No: D3200-1

Job Qty: 15 ea

DAS
21
9-89

Part Name: Door Post Block

22 ea



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-2		DAS 18/09/18
100	Bandsaw	15 pcs	9/7/18	9/7/18	0.00	0.14	Bandsaw1		522 18/09/18
110	CNC Vertical Machining	15 pcs	9/7/18	9/7/18	0.07	4.93	HAAS1-3		9-89 18/09/18
130	QC	15 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-2		18/09/18
140	Packaging	15 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1	St022	SEP 18 2018
150	QC21-SA	15 Ea	9/7/18	9/7/18	0.00	0.00	QC21		SEP 18 2018

Part Op 100 - Cut blank: 2.700" x 2.700

Descriptions: 110 - 1-Machine D3200-1 as per Folio FA337 and Dwg D3200

DAS
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	.7500 sf (.05 ea)	90-Start up Operation	FA130453 5045595 809392

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	1	1,051	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Post Block	0.196inches + 0.005 - 0.000	0.201 0.196	0.198	
2	Door Post Block	0.405inches ± 0.010	0.415 0.395	0.405	
3	Door Post Block	100Degrees ± 0	100 100	100°	
4	Door Post Block	0.100inches ± 0.010	0.110 0.090	R: 0.100	
5	Door Post Block	0.130inches ± 0.010	0.140 0.120	R: 0.130	
6	Door Post Block	1.630inches ± 0.005	1.635 1.625	1.630	
7	Door Post Block	0.440inches ± 0.030	0.470	0.435	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	QTY Effective : _____			MRB (QSI042) Approval	
Part: D3200-1 Job No: 182257 Serial No/Batch: S109393 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/11/18				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offsets ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

			0.410		
8	Door Post Block	2.500inches ± 0.010	2.510 2.490	2.500	
9	Door Post Block	1.845inches ± 0.010	1.855 1.835	1.837	
10	Door Post Block	1.000inches ± 0.010	1.010 0.990	1.000	
11	Door Post Block	1.620inches ± 0.050	1.670 1.570	1.621	
12	Door Post Block	2.500inches ± 0.030	2.530 2.470	2.500	DAS 52
13	Door Post Block	0.750inches ± 0.030	0.780 0.720	0.748	9-89 18/09/11

Plex 8/21/18 11:06 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



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